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RBE350A93-3710-00-10

Job Sheet 196929



Part No: RBE350A93-3710-00-10

Job Qty: 2 pcs

Part Name: Pedestal Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/25/19

Job Tracking No:

Due Date: 6/28/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG RBE350A93-3710-00 Rev 1A IPP Rev. A 19.04.26 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
No					Hrs	Hrs			
100	Small Fab - 1	2 pcs	6/28/19	6/28/19	0.00	0.50	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		MCC
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
		2 pcs	6/28/19	6/28/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
120	NV5000 - 1 - B4B	2 pcs	6/28/19	6/28/19	1.00	2.00	NV5000 - 1 - B4B		J.C.L.
							NV5000 - 2 - B4B		
130	QC 2	2 pcs	6/28/19	6/28/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		J.C.L. 19-07-18
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		



Container No: S198525



Part: RBE350A93 - 3710 - 00 - 10

Job No: 196929

Serial No/Batch: S198525

Revision: 1A

Inspector:

Exp Date:

Instructions:

Date: 07/17/19

DAS
81
9-89

JUL 17 2019

Plex 6/25/19 2:12 PM Dart.Renwick.Jennife

				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
135	Conventional Mill - 1 - B4B	2 pcs	6/28/19	0.00 1.00	Conventional Mill - 1 - B4B
					Conventional Mill - 2 - B4B
136	QC 2	2 pcs	6/28/19	0.00 0.00	QC 2 - 1
					QC 2 - 12
					QC 2 - 14
					QC 2 - 17
					QC 2 - 19
					QC 2 - 2
					QC 2 - 20
					QC 2 - 22
					QC 2 - 23
					QC 2 - 25
					QC 2 - 32
					QC 2 - 33
					QC 2 - 35
					QC 2 - 39
					QC 2 - 4
					QC 2 - 40
					QC 2 - 44
					QC 2 - 45
					QC 2 - 48
					QC 2 - 49
					QC 2 - 50
					QC 2 - 51
					QC 2 - 52
					QC 2 - 57
					QC 2 - 62
					QC 2 - 63
					QC 2 - 8
					QC 2 - 66
					QC 2 - 64
					QC 2 - 65
					QC 2 - 5
					QC 2 - 71
					QC 2 - 73
					QC 2 - 69
140	QC 8	2 pcs	6/28/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8

					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
150	Small Fab - 2 - B4B	2 pcs	6/28/19	0.00 0.40	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	MLL
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
160	QC 5	2 pcs	6/28/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
170	Packaging 3-1 - Stock - B4B	2 pcs	6/28/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	MLL
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	DAS
					Packaging 3 - 36 - B4B	21
180	QC 21 - SA	2 pcs	6/28/19	0.00 0.00	QC 21 - SA - 21	9-35 11 1 8 2019

QC 21 - SA - 70

QC 21 - SA - 53

GA
TBD

Part Op 100 - 1-Press in -21 legs into -20. ***apply a small amount of LOCTITE 262 prior to pressing in the legs, wipe off Descriptions: excess.***

120 - 1-Machine as per folio FC838 FOLIO REV: AA DWG REV: 2A 2-Deburr

130 - QC2- Inspect parts off machine FAI/FAIB

135 - Transfer drill holes for roll pins.

140 - QC8- Inspect parts - second check

150 - 1-Install roll pins. 1-Touch up legs (RBE350A93-3710-00-21) with gun blue as per drawing sheet 4. 2-Paint scribe line red on RBE350A93-3710-00-20 as per drawing sheet 3.

170 - Identify as per dwg & Stock Location: _____

180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE350A93-3710-00-20	Pedestal	2 pcs (1 ea)	100-Small Fab - 1	
RBE350A93-3710-00-21	Leg	6 pcs (3 ea)	100-Small Fab - 1	<u>5193874</u>
91611A170	Roll Pin	6 Ea (3 ea)	150-Small Fab - 2 - B4B	<u>5184141</u>

143B
5A051

Job Allocations

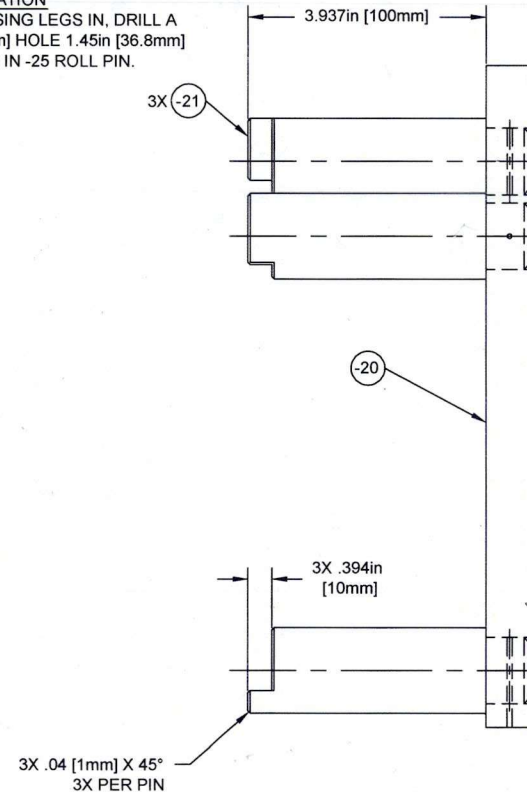
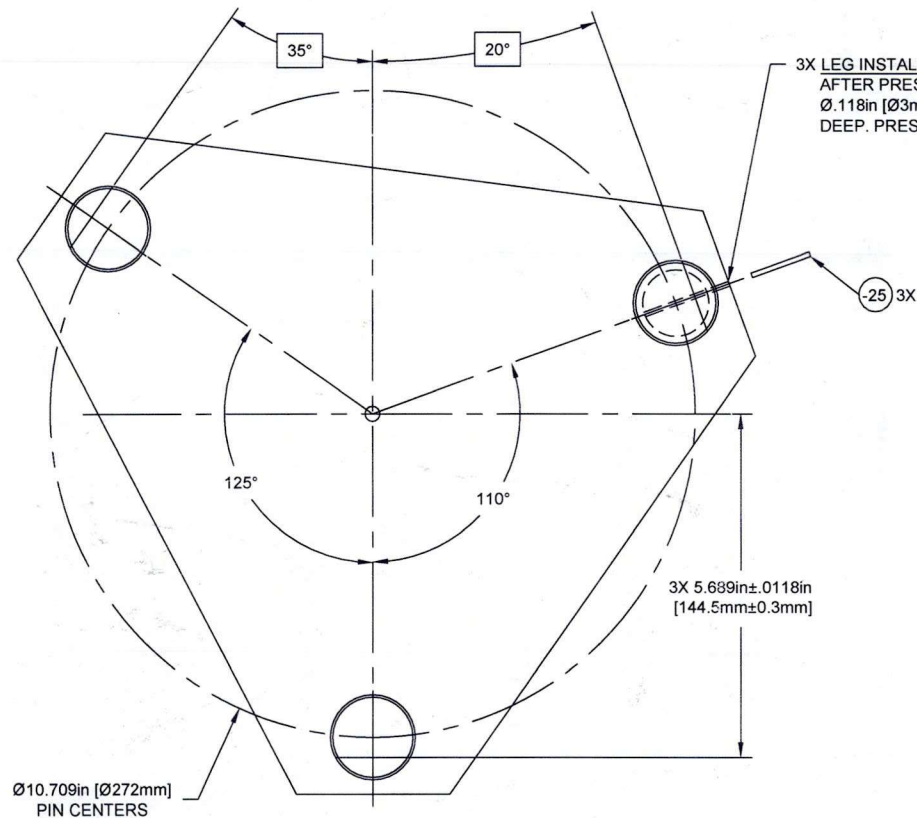
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	RBE350A93-3710-00-20	2	0	0
	RBE350A93-3710-00-21	6	0	0
150-Small Fab - 2 - B4B	91611A170	6	100	0

Part Specifications

Specifications could not be found.

Plex 6/25/19 2:12 PM Dart.Renwick.Jennifer

REV		DESCRIPTION	DATE	INITIAL	APPROVED
1		CH'D SPECIFICATION -22 IN BOM, ADDED A TO -20 & -21, ADDED GUN BLUE NOTE TO -10 & -21 PER R.W. CH'D LENGTH -25 FROM 20MM TO 25MM TO ALLOW -21 TO BE REMOVED FROM -20. CH'D HOLE DEPTH FOR -25 FROM 1-3/8 TO 1.45in. [36.83mm]	2/9/10	RJC	RW



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 195105 MWS
190514
196929

- NOTES:
1. LEG INSTALLATION PROCEDURE.
 2. 3X MACHINE LEG STEP TO DIMENSIONS SHOWN.
 3. 3X CHAMFER LEG AS SHOWN.
 4. AFTER MACHINING LEGS USE LIQUID GUN BLUE TO BLACKEN LEGS.
 5. SOME HIDDEN LINES HAVE BEEN REMOVED FOR CLARITY.

RED BARN MACHINE	
TITLE EXTRACTOR PLATE FIXTURE	
DWG NO. RBE350A93-3710-00-10	REV 1A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS IN XXX ± .0039 XX ± .01 X ± .1	METRIC X X mm ± 0.1 mm IN. FRACTIONS ± 1/32 ANGLES ± 5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 X 45° PER 015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 12-21-09
SHEET 2 of 5	

-10
PEDESTAL ASSEMBLY

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD	Work Order: 196 9204
Description: pedestal Assembly	Part Number: RDE350A93-5710-00010
Inspection Dwg: RDE350A93- Rev: 1A	Page 1 of 1

INSPECTION SHEET

[illegible]

Measured by: <u>S.C. L / 11/11/18</u>	Checked by: <u>Ba</u>	QC Inspector:
Date: <u>11-07-18</u>	Date: <u>19-07-18</u>	Date:

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	